

Date: Thursday, 07/05/2009 2:41:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 47788	
Estimate Number : 12660	
P.O. Number :	Part Number : D35741
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D3574 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 46509	Material :
Written By :	Due Date : 11/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.05.07</u>	
Comment : Est Rev :A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



Comment: Qty.: 33.6000 sf(s)/Unit Total : 201.6000 sf(s)
 lexan sheet

Batch: 11710 B 9-5-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3574
 Dwg Rev: A
 Prog Rev: A

B 9-5-12

⑥

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

507/05/13 KG

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

ep

09/05/13

⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 47788

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/13 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: PPP 47677

PC 9/5/14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14 JG

Job Completion



MF
09-05-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47788
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-1
Inspection Dwg: D3574-1 Rev: B		Page 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+0.02 -0.001	3.002	X			
7.37	±.030	7.37	X			
10.75	±.030	10.75	*			
11.00	±.030	11.00	*			
15.25	±.030	15.25	*			
25.87	±.030	25.87	*			
39.75	±.030	39.75	X			
44.75	±.030	44.75	*			
49.11	±.030	49.11	X			
51.11	±.030	51.11	X			
53.51	±.030	53.51	*			
63.50	±.030	63.50	*			
65.25	±.030	65.25	*			
10.75	±.030	10.75	*			
11.06	±.030	11.00	*			
14.75	±.030	14.75	X			
25.50	±.030	25.50	*			
25.75	±.030	25.75	*			
26.06	±.030	26.00	X			
32.87	±.030	32.87	X			
38.81	±.030	38.81	X			
44.75	±.030	44.75	*			
45.00	±.030	45.00	X			

Measured by: IB	Audited by: S	Prototype Approval: 1/
Date: 9-5-12	Date: 09/05/13	Date: 1/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten signature]

DART AEROSPACE LTD		Work Order: 47788
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-1
Inspection Dwg: D3574-1 Rev: 8		Page 2 of 3

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
48.25	± .030	48.25	*			
58.38	± .030	58.38	*			
61.25	± .030	61.25	*			
64.13	± .030	64.13	*			
64.63	± .030	64.63	*			
66.50	± .030	66.50	*			
7.50	± .030	7.50	*			
9.58	± .030	9.58	*			
10.38	± .030	10.38	*			
10.88	± .030	10.88	*			
14.50	± .030	14.50	*			
16.56	± .030	16.56	*			
18.75	± .030	18.75	*			
24.13	± .030	24.13	*			
26.50	± .030	26.50	*			
30.50	± .030	30.50	*			
33.88	± .030	33.88	*			
39.50	± .030	39.50	*			
40.25	± .030	40.25	*			
43.50	± .030	43.50	*			
43.83	± .030	43.83	*			
46.60	± .030	46.60	*			
7.63	± .030	7.63	*			

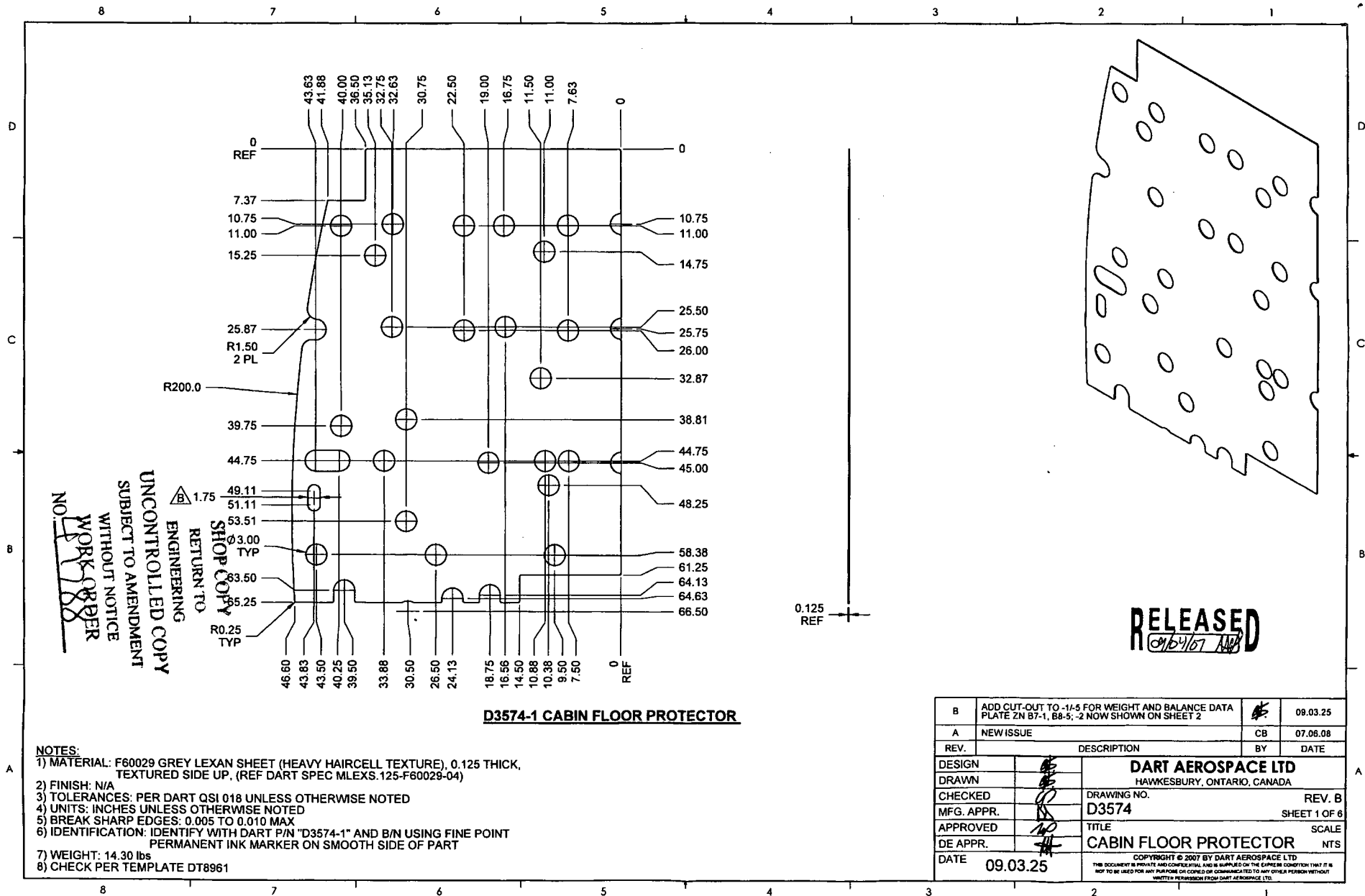
Measured by: RB
Date: 9-5-12

Audited by: S
Date: 9/5/12

Prototype Approval: 1
Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten signature]



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

NO. 1788
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

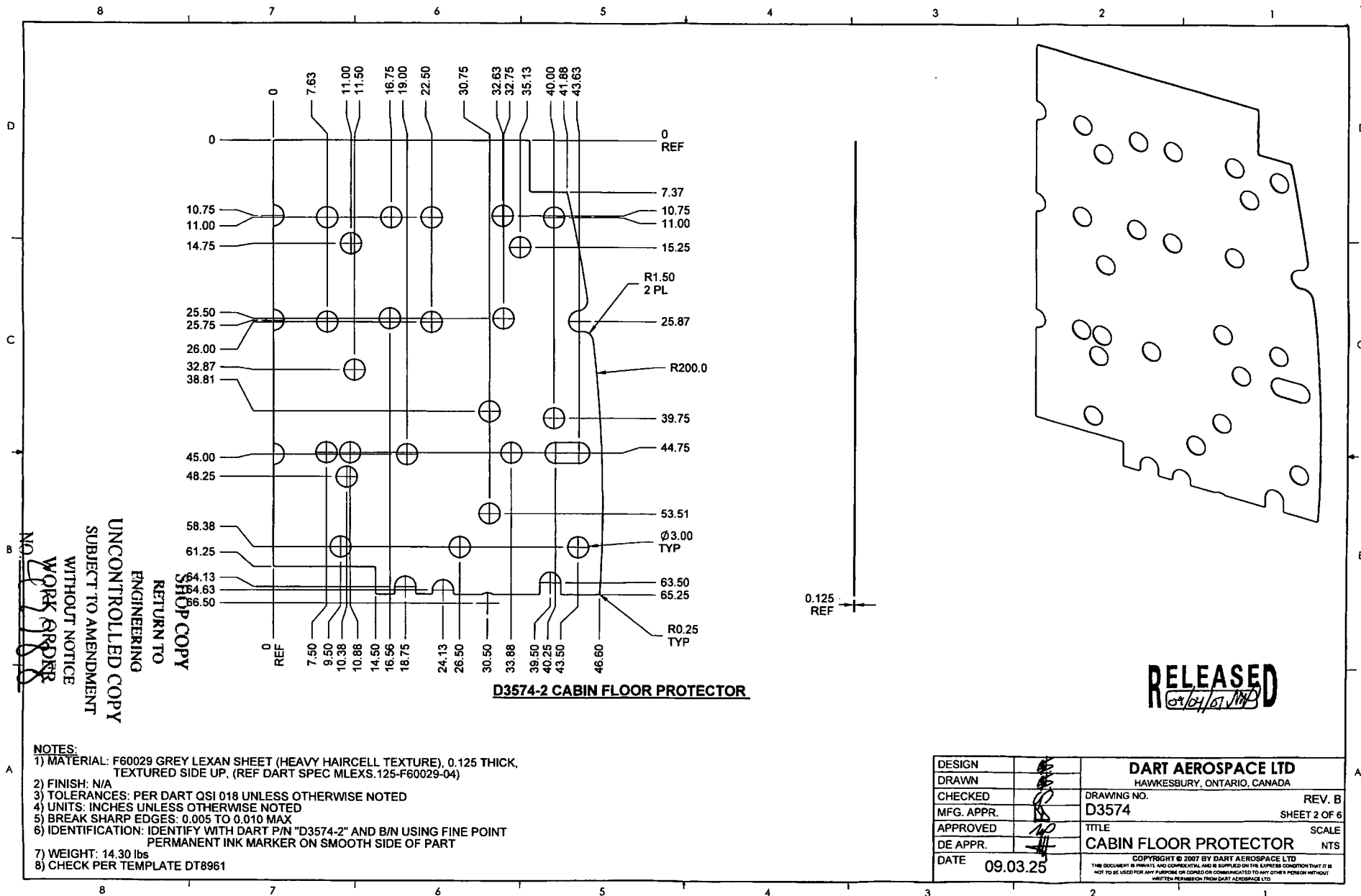
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



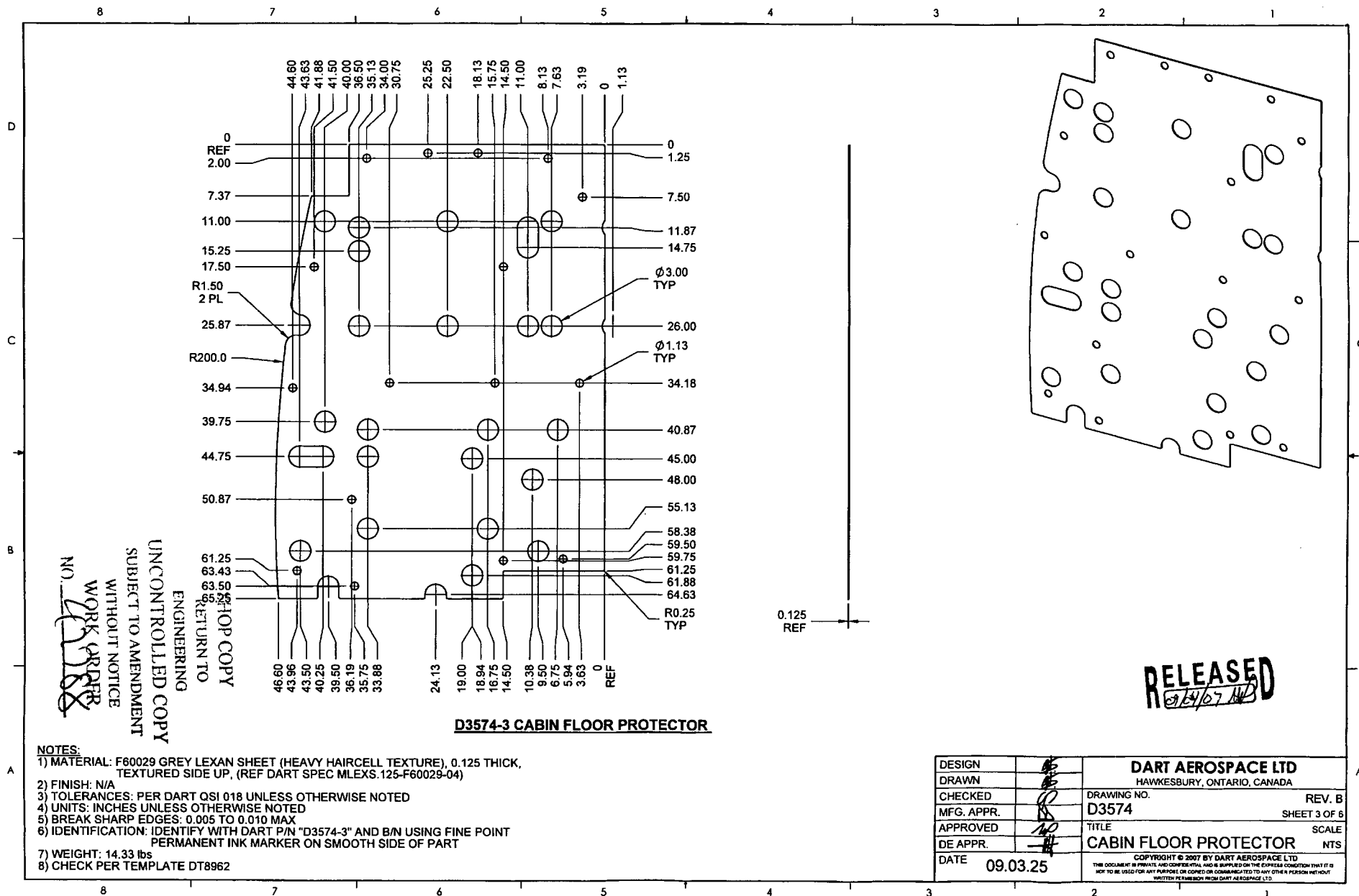
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



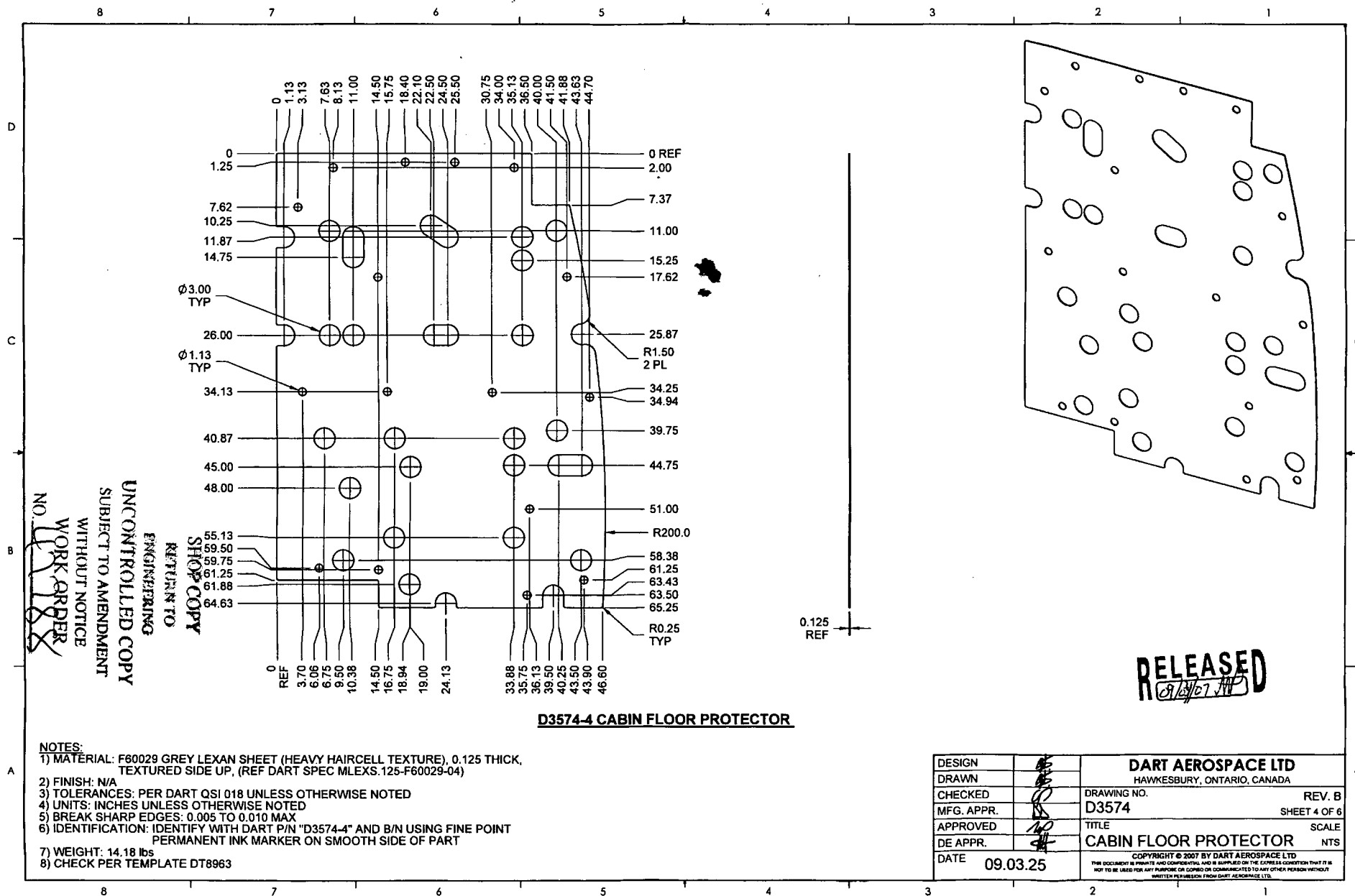
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NOTE: Date & initial all entries



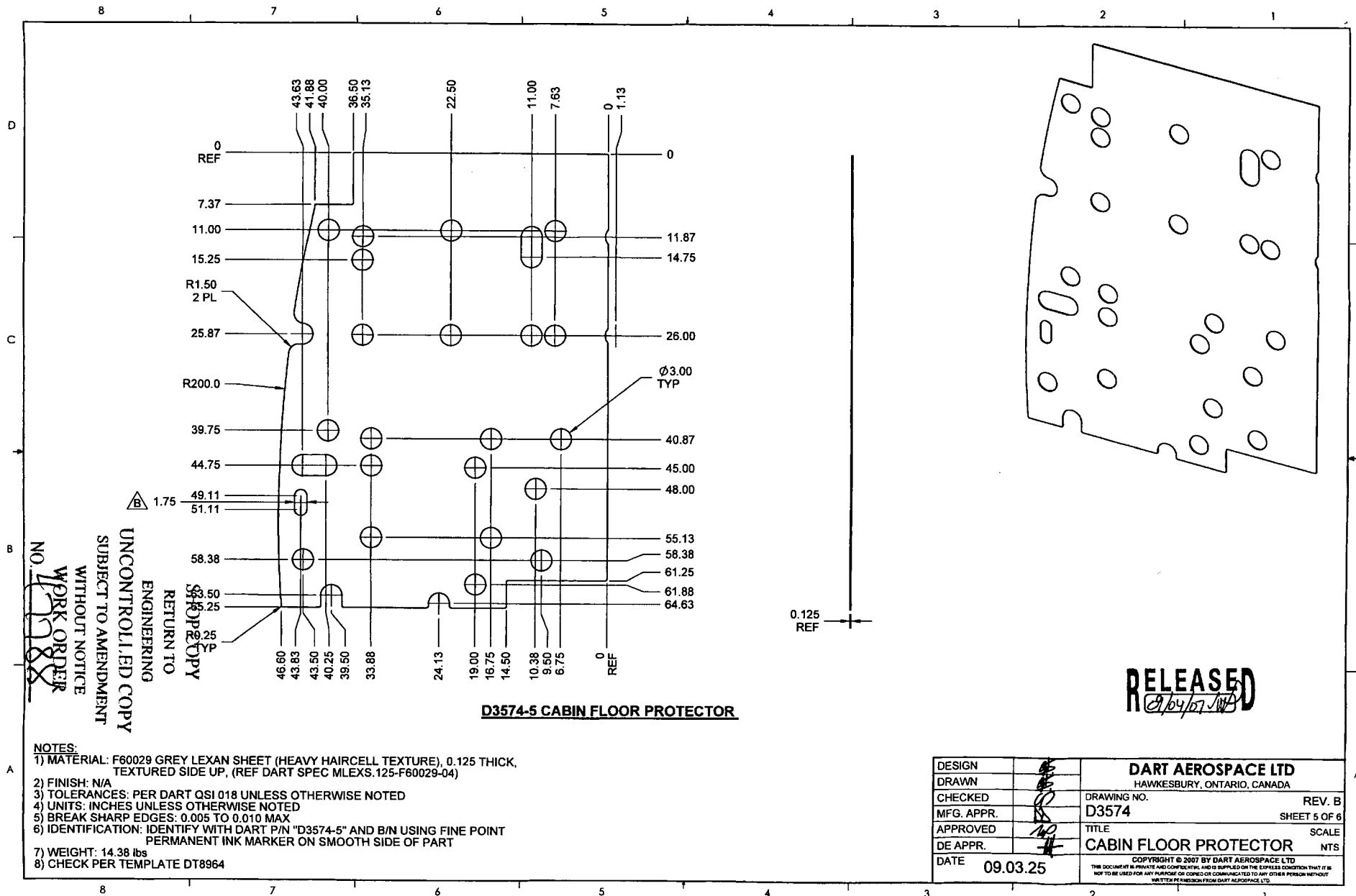
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.38 lbs
- 8) CHECK PER TEMPLATE DT8964

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 12788
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT

RELEASED
01/04/17 JMB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.		SHEET 5 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

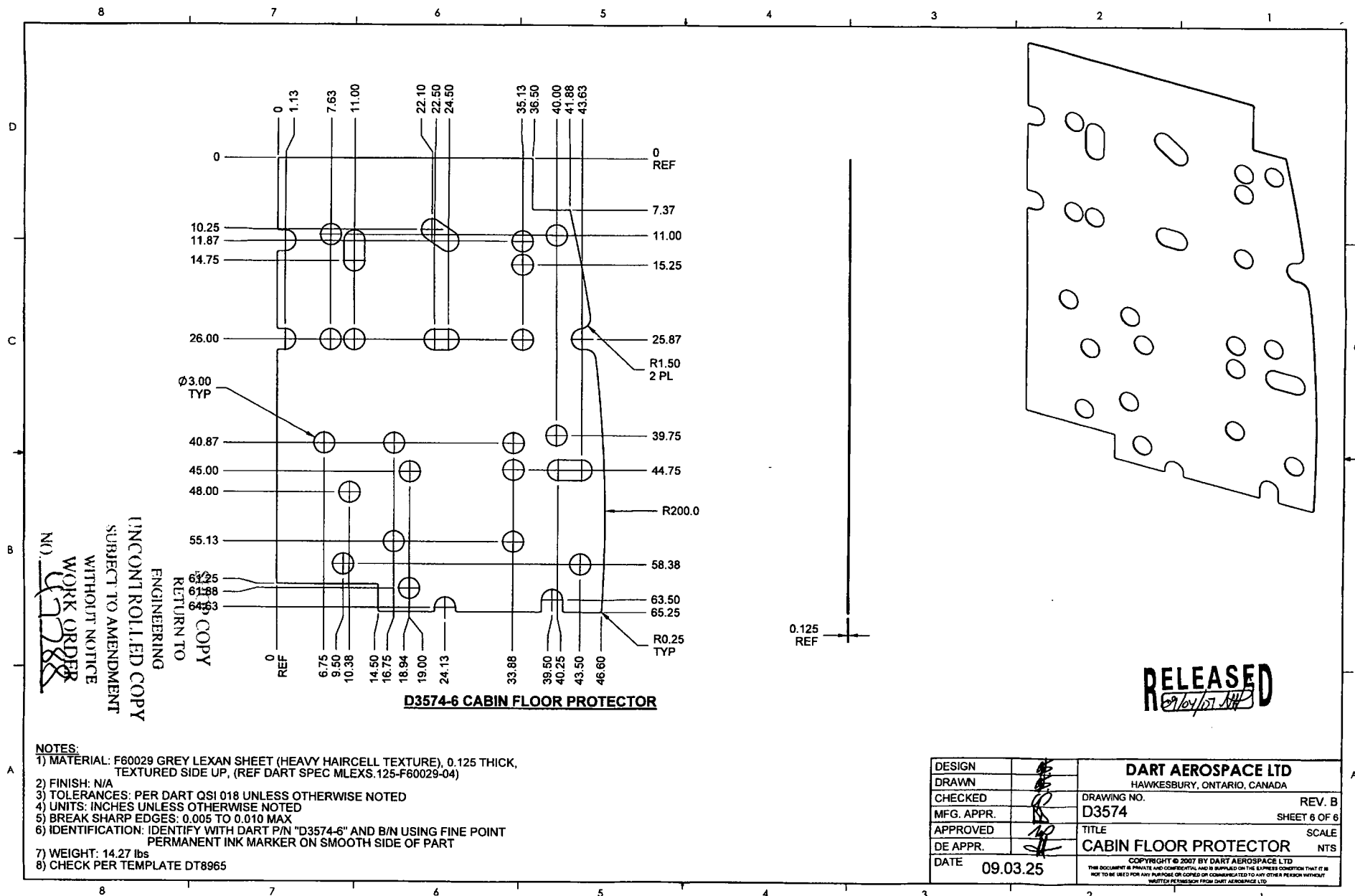
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries